

Work Order ID 105495

105495

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Item ID: D2550-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly
 Start Date: 8/07/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/16/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1	0		<i>13-08-14</i>
132 *132* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				1X			<i>13/08/14</i>
134 *134* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <i>125127</i> Memo 1- Weld cap as per dwg and grind flush 2- Touch up alodine	0.00 0.00				1	0		<i>13-08-14</i>

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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136 *136* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00 13.8.14				1			
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138 *138* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 13.8.14				1			
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140 *140* Powdercoat Powder Coating	Black Sanding (Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: _____ FINISH TIME: _____ OVEN TEMPERATURE: _____	0.00 0.00							
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W126125

320°F

9:30

1X PM 13/08/15

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 Item Name: Step Assembly
 Start Date: 8/07/13 Start Qty: 1.00 *1* Cust Item ID:
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch Memo	0.00				1x	d	M 13108115	
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00				1			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00						13/8/16sf	

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Item ID: D2550-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Assembly

Start Date: 8/07/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/16/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

13/8/2013
MW 13-08/16

Picklist Print

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Work Order ID: 105495
Parent Item: D2550-1
Parent Item Name: Step Assembly

Start Date: 8/07/13

Required Date: 8/16/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP F 00.06.26Removed P/O for powder coat, added level 9 inspectionEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			100	Each	174.3700	1	1		8.13.08.12	

Location	Loc Qty	Loc Code
WA003	174.37	
101765	118	
81507	4	
89750	8.27	
98024	2.1	
99789	42	

D2875 End Plate		Manufactured	No			100	Each	10.0000	1	1		8.13.08.12	
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Location	Loc Qty	Loc Code
WA003	10	
45665	10	

D2875 End Plate		Manufactured	No			134	Each	10.0000	1	1		8.13.08.14	
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Location	Loc Qty	Loc Code
WA003	10	
45665	10	

D2936-1 Lug		Manufactured	No			100	Each	2.0000	3	3		8.13.08.12	
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Location	Loc Qty	Loc Code
Mezz B105502	2	
11868	2	

D2936-3 Lug		Manufactured	No			100	Each	2.0000	3	3		8.13.08.12	
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Location	Loc Qty	Loc Code
Mezz B105503	2	
2197	2	



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2550	REV. F SHEET 1 OF 2
DATE 99.11.03		TITLE STEP ASSEMBLY	SCALE NTS
A	96.03.28	NEW ISSUE	
B	97.04.03	CHANGE EXTRUSION AND LEGS	
C	97.07.18	ADD WING WALK SPEC	
D	97.09.10	CHANGED LEGS	
E	99.10.20	D2875 WAS D2669-45	
F	99.11.03	ADDED D2936, REMOVED D2695/96/97	

RELEASED
KE 99.11.19

Qty -1	Qty -2	Part Number	Description
X		D2550-1	HELI-ACCESS-STEP™ LH, HEAVY DUTY
	X	D2550-2	HELI-ACCESS-STEP™ RH, HEAVY DUTY
*	*	* D2622	* EXTRUSION
2	2	D2875	END PLATE
3	3	D2936-1	LUG
3	3	D2936-3	LUG

* NOTE: CUT EXTRUSION D2622 PER SHEET 2

*info
105495*

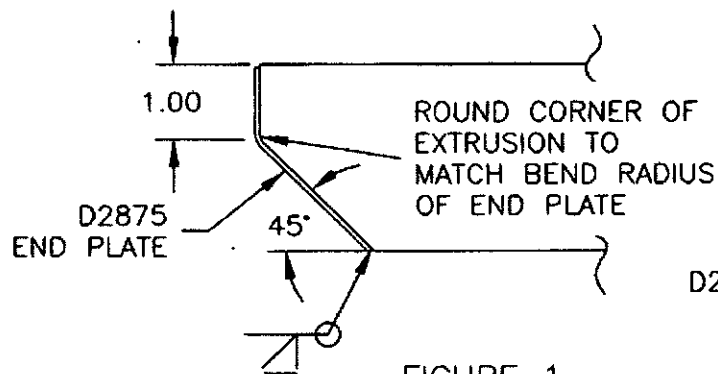
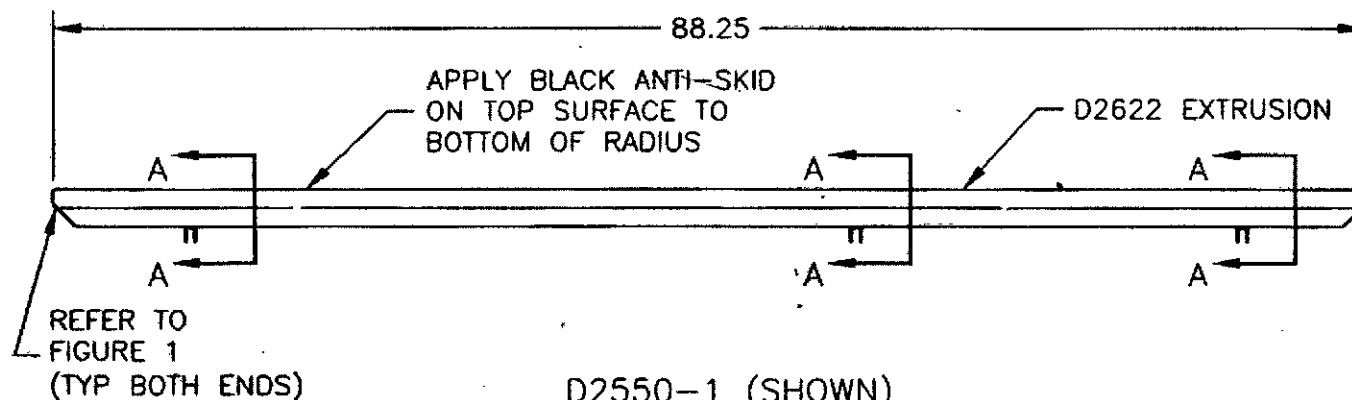
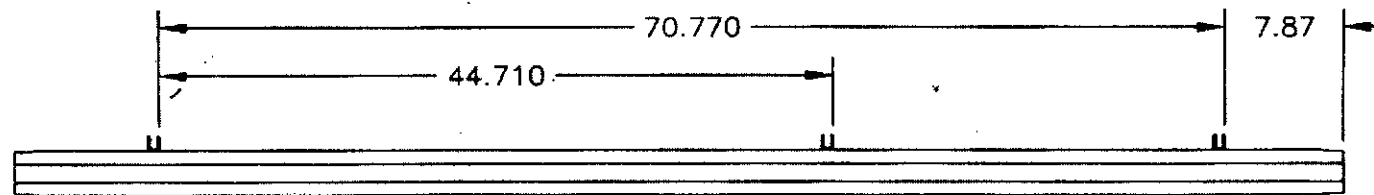
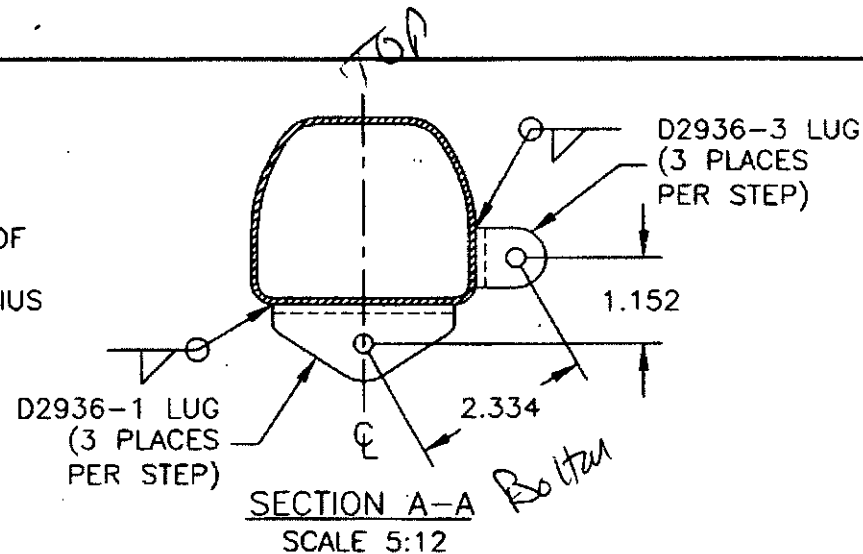


FIGURE 1
SCALE 5:12



D2550-1 (SHOWN)
D2550-2 (OPPOSITE)

WELD PER DART QSI 004
FINISH: ACID ETCH AND ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT PER DART QSI 005 4.3 WHITE (4.3.5.1) OR
GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7)
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4 AFTER POWDER COAT
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART



DESIGN	HE	DRAWN BY	HE	DART AEROSPACE LTD
CHECKED	HE	APPROVED	HE	HAWKESBURY, ONTARIO, CANADA
DATE	99.11.03	DRAWING NO.	D2550	REV. F
TITLE	STEP ASSEMBLY	SHEET	2 OF 2	SCALE
				1:12

RELEASED
RLE 99.11.14

